

52

DART AEROSPACE LTD	Work Order:	22112
Description: Doubler	Part Number:	D3302-5
Dwg: D3302 Rev. <i>AB 31/12/16</i> <i>04.11.25 PS</i>	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	<i>KJ</i>	04.12.16	10
2	MV	Cut blank: 12.450" x 8.750" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-5 Batch: <i>M16455</i>	<i>CPL</i>	05-01-17	10
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-5	<i>EP</i>	05.01.18	10
4	QC2	Inspect parts as they come off the CNC machine	<i>EP</i>	05.01.18	10
5	QC8	Second check	<i>EP</i>	05.01.19	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	<i>Z</i>	05.01.19	10
7	GB	Form as per Dwg D3302	<i>Z</i>	05.01.27	10
8	QC5	Inspect work to Step 7	<i>B</i>	05.01.31	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>MT</i>	05.02.02	10
10	QC3	Inspect Chemical Conversion Coat	<i>U</i>	05.07.07	10
11	ST	Identify and Stock	<i>U</i>	05.02.02	10
12	AC	Cost / part <i>14.60</i>	<i>595</i>	05.02.03	10
13	DC	Close W/O <i>14.60</i> Inspect Level 21	<i>KJ</i>	05.02.04	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
[Signature] 09.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22112
Description: Doubler		Part Number:	D3302-5
Inspection Dwg: D3302	Rev: A B 11 12/16 04.09.18	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.327	+/-0.010	12.327	—			
10.62	+/-0.030	10.625	—			
→ 8.000	+/-0.005					Not on Dwg
1.000 pitch	+/-0.005					
0.851	+/-0.010	0.851	—			
0.851	+/-0.010	0.851	—			
8.702	+/-0.010	8.702	—			
7.00	+/-0.030	0.700	—			
R0.12	+/-0.030	0.120	—			
→ 1.101	+/-0.010					Not on Dwg
→ 2.000	+/-0.005					Not on Dwg
1.000 pitch	+/-0.005					
→ 3.000	+/-0.005					Not on Dwg
→ 2.000	+/-0.005					Not on Dwg
→ 2.663	+/-0.010					Not on Dwg
→ 2.163	+/-0.010					Not on Dwg
0.063	+/-0.010					Not on Dwg
0.098	+0.005/-0.000					MAT. Thickness

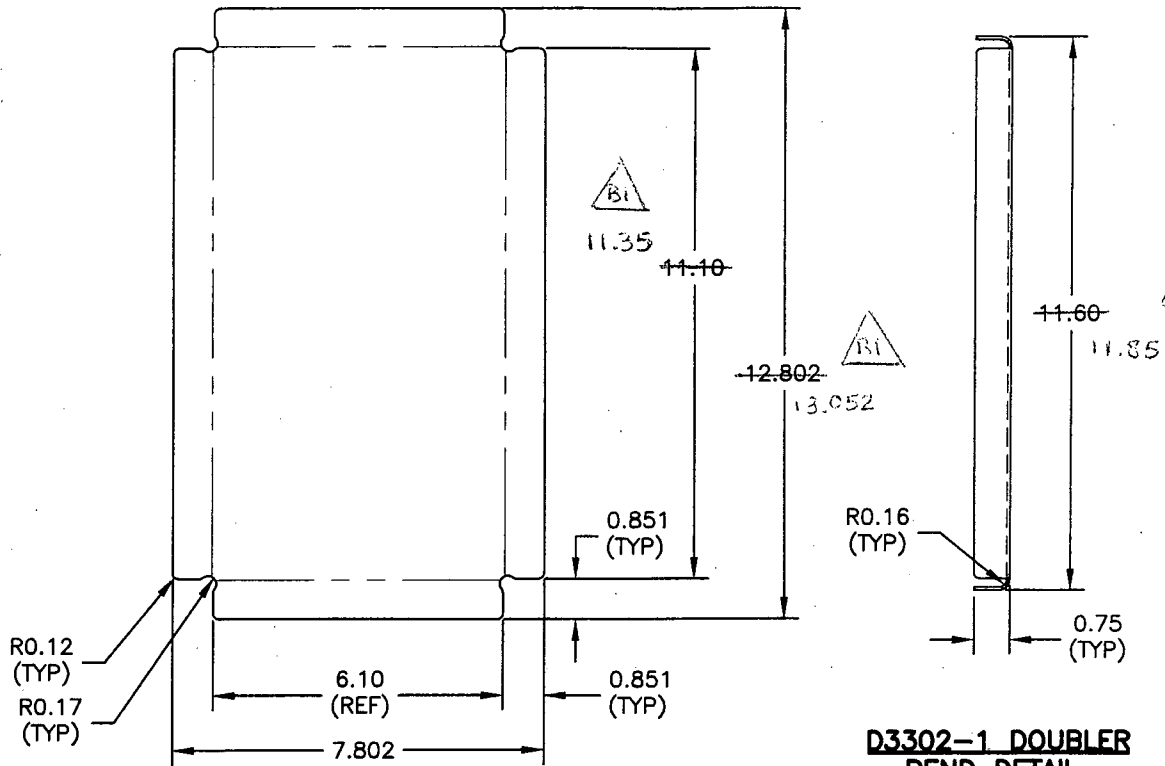
Measured by: ER	Audited by: [Signature]	Prototype Approval:	N/A
Date: 05.01.18	Date: 05.01.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	[Signature]

RECEIVED
01.07.02

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
Bi	04.12.15	ADDED 0.25" TO THE LENGTH	

RELEASED
04.11.23 #**D3302-1 FLAT PATTERN****D3302-1 DOUBLER
BEND DETAIL****SHOP COPY
RETURN TO
ENGINEERING****UNCONTROLLED COPY
REVISION
NOT NOTICE****WORK ORDER
NO. 22112****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

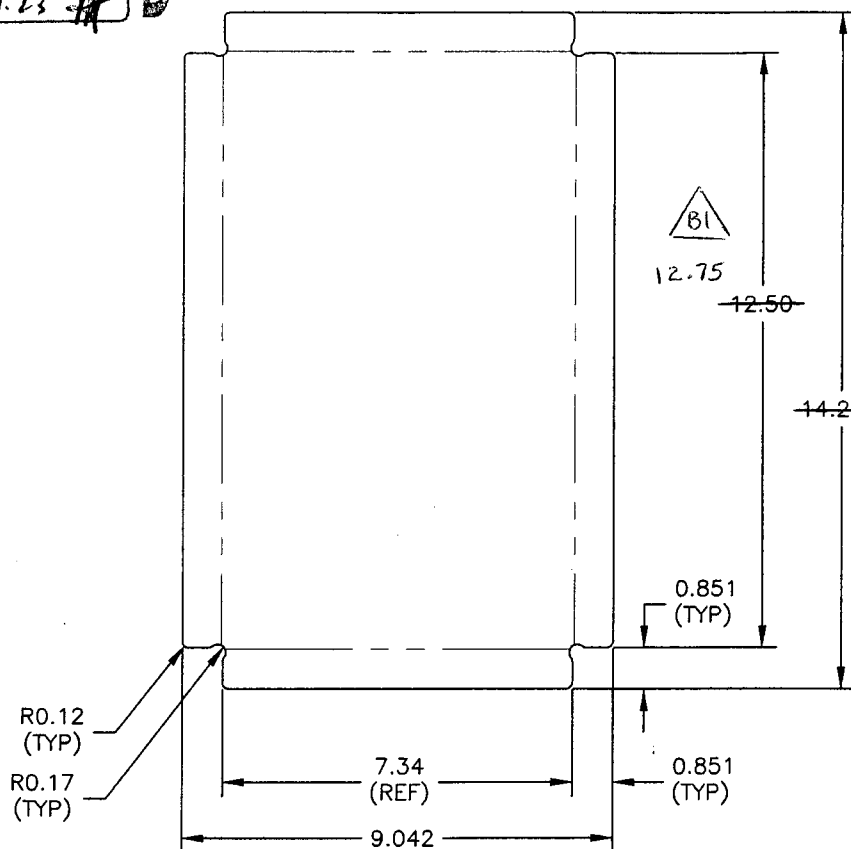
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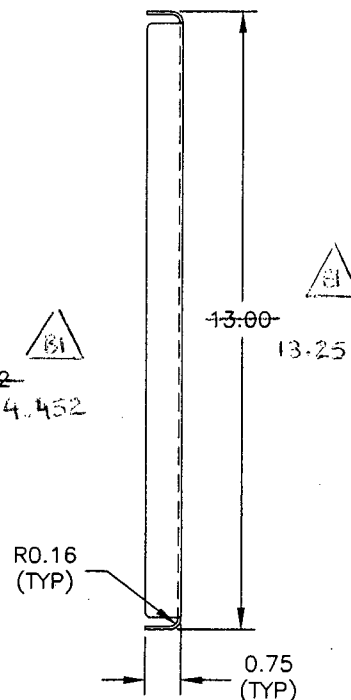


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

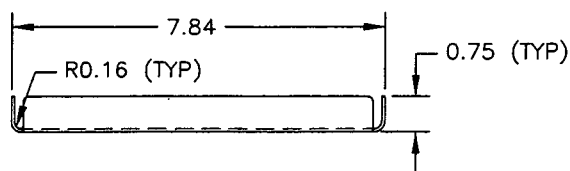
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04.11.23 H



D3302-3 FLAT PATTERN



**D3302-3 DOUBLER
BEND DETAIL**



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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NO AMENDMENT
WITHOUT NOTICE
**WORK ORDER
NO. 22112**

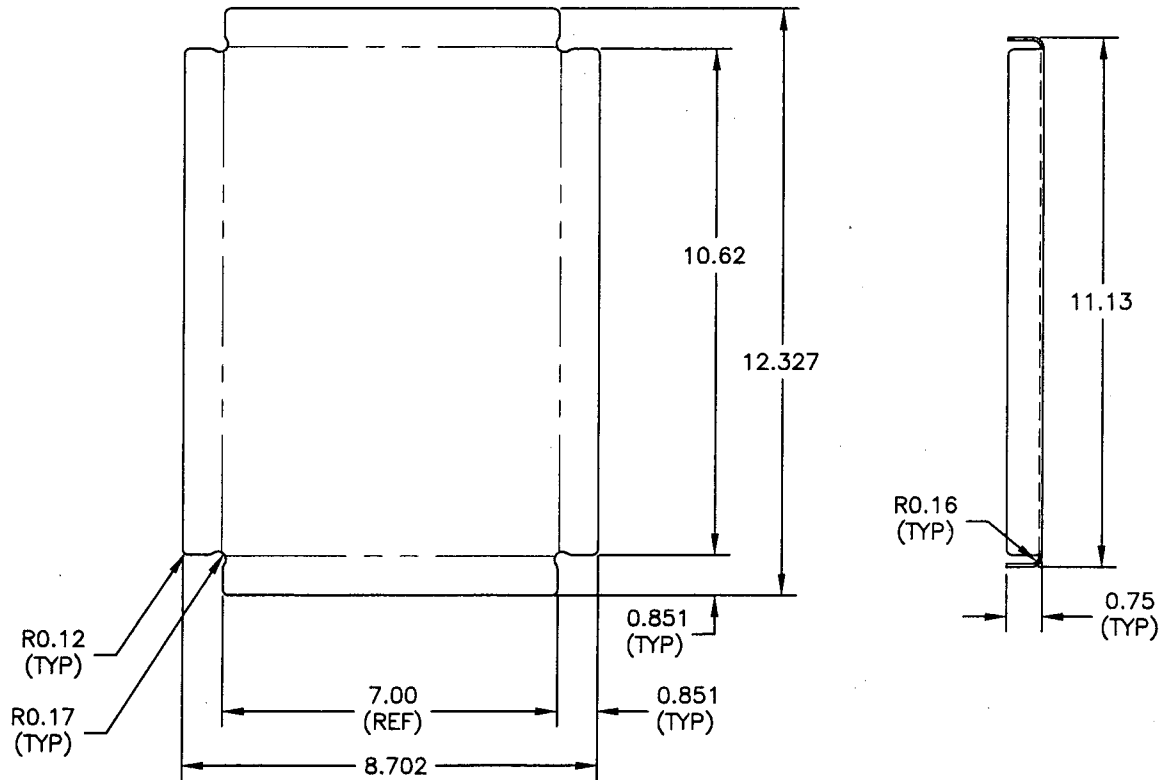
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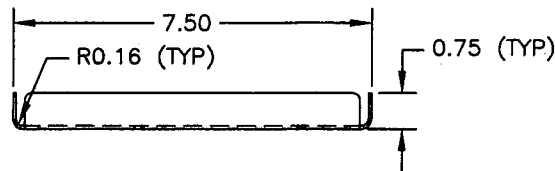


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08	TITLE DOUBLER		SCALE 1:4

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04.11.23 [Signature]



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL
SHOP COPY**

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EXCLUDED FROM DOCUMENT
NOTICE

WORK ORDER

NO. 22112

D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

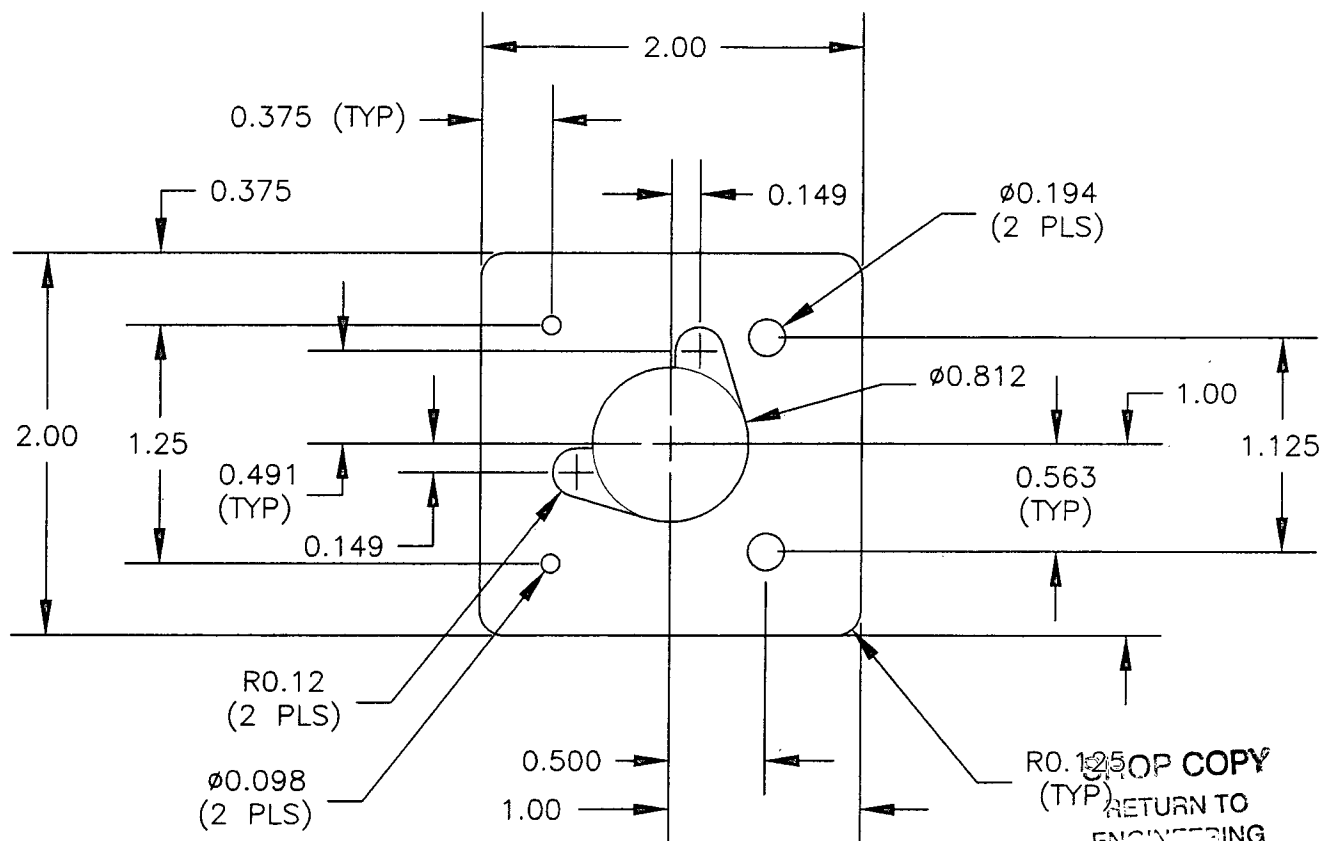
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18	TITLE DOUBLER		SCALE 1:1

RELEASED
04.11.23



D3302-7

GROUP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO COMMENT
WITHOUT NOTICE

WORK ORDER
NO. 22112

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 16, 2004
12:38 pm

Work Order No : 0022112
Project Name : D3302-5
Project For : WK452
Work Order Type : Main
Main WO Number :
House Part Number : D3302-5
Description : Doubler
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 12-16-04
Est Finish Date : 12-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00